

AD02

5. CNC Machining - Slot

- a. Install vise jaw 84267-02 on far side of vise, install 3" tall jaw on close side.
- b. Set G54 O's to top left far corner of vise jaw. Offset Y to accommodate material thickness (i.e. 0.78" material, offset $0.75-0.78 = -0.03/2 = -0.015$). Confirm on first run.
- c. Run CNC program 84206. Use cordless drill to open/close vise.
- d. Repeat c for all parts.
- e. Tag in-progress parts and place on in-progress shelf in fabrication shop for finishing.

6. Finishing

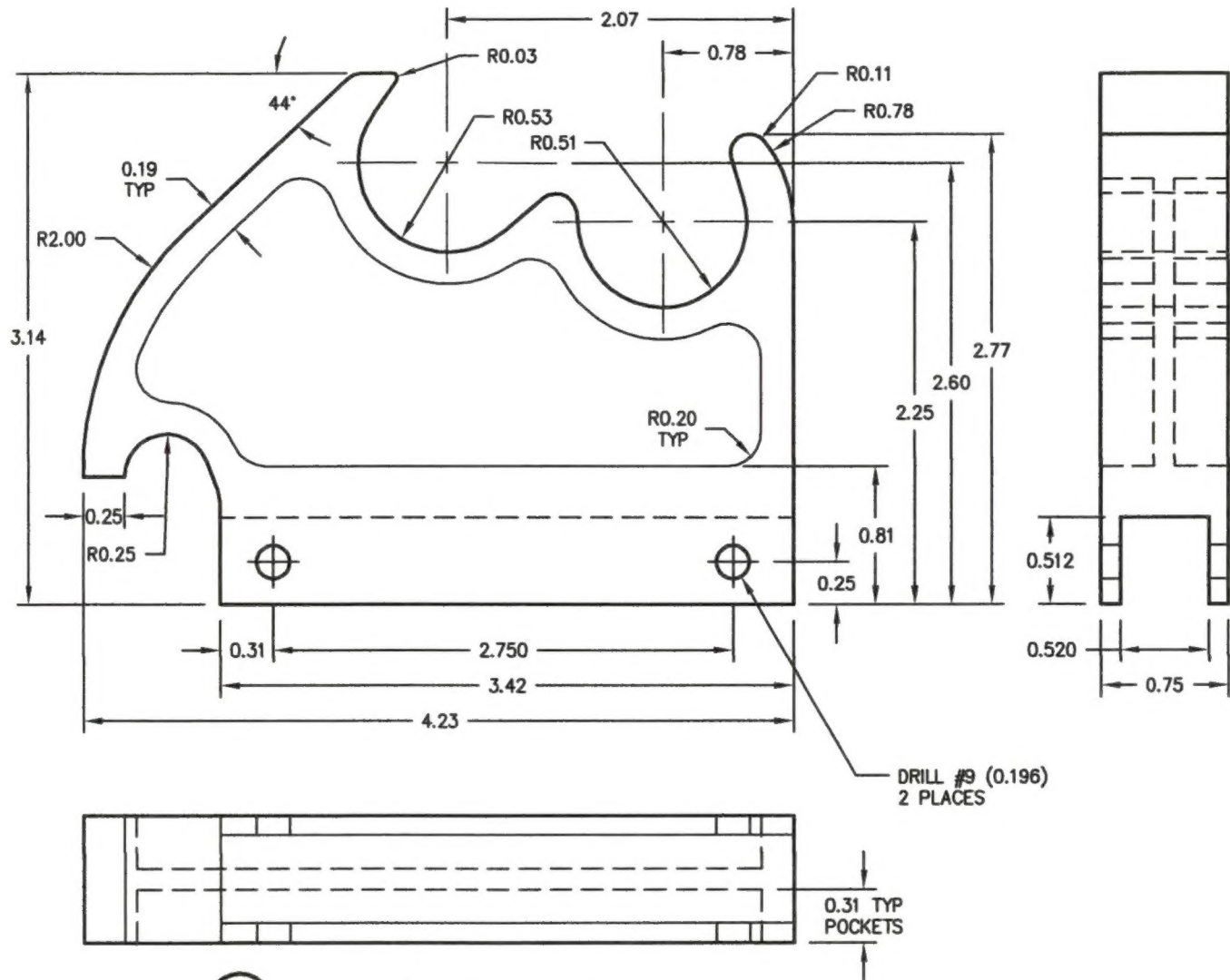
- a. Deburr all edges.
- b. Visually inspect parts for cracks or damage. Pay particular attention to flanges on ½" slot.
- c. Green tag complete handle brackets and place into stock.

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[illegible]

2014-48

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED	BJC	MAR 13/14



01 HANDLE BRACKET

PART TO BE CNC MACHINED USING DRAWING AS A TEMPLATE

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
84267-01	01	HANDLE BRACKET	ACETAL PLASTIC	COMMERCIAL	0.75 SHEET

QTY

LIST OF MATERIALS

APPROVALS

DATE

DRAWN: R. RATHWELL JUNE 18/09

CHECKED: E. BURGAIN

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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**HELICOPTER CARGO BASKET
HANDLE BRACKET**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84267	1

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